Date: Tuesday, 1/23/2007 7:33:08 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: TOW RING
Job Number	: 30394		
Estimate Number	: 10794		
P.O. Number	: N/A	**Part Number**	: D3407041
This Issue	: 1/23/2007 **S.O. No.** : N/A	**Drawing Number**	: D3407 REV C
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: C
Previous Run	: 28321	**Material**	: N/A
Written By	:	**Due Date**	: 2/15/2007 **Qty:** 20 **Um:** Each
Checked & Approved By	: 07.01.23		
Comment	: Est Rev.A 05.10.14 New issue KJ/EC		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D34071	Stem

Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3407-1 Stem B304101 FC 07/03/21 (22)

Seq. #:	Machine Or Operation:	Description :
2.0	D34075	Ring

Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3407-5 Ring B30402 FC 07/03/21 (22)

Seq. #:	Machine Or Operation:	Description :
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004
A/R TIG174 ROD Batch: M18779 FC 07/03/21 (22)

Seq. #:	Machine Or Operation:	Description :
4.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07/03/21 (22)

Seq. #:	Machine Or Operation:	Description :
5.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07/03/21 (22)

Form: rprocess

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes (No) **DQA:** [initials] **Date:** 07/03/27

QA: N/C Closed: ______ **Date:** ______

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** TOW RING

Job Number: 30394 **Part Number:** D3407041

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
6.0	POWDER COATING	POWDER COATING

m103706

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
Mask Threaded Section

07/03/21 (22)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 22 07/3/26

8.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_______ 07/3/26 22 7/03/25 (22)

9.0	QC21	FINAL INSPECTION/W/O RELEASE

(22)

Comment: FINAL INSPECTION/W/O RELEASE 07/03/27

Job Completion

07 03 27

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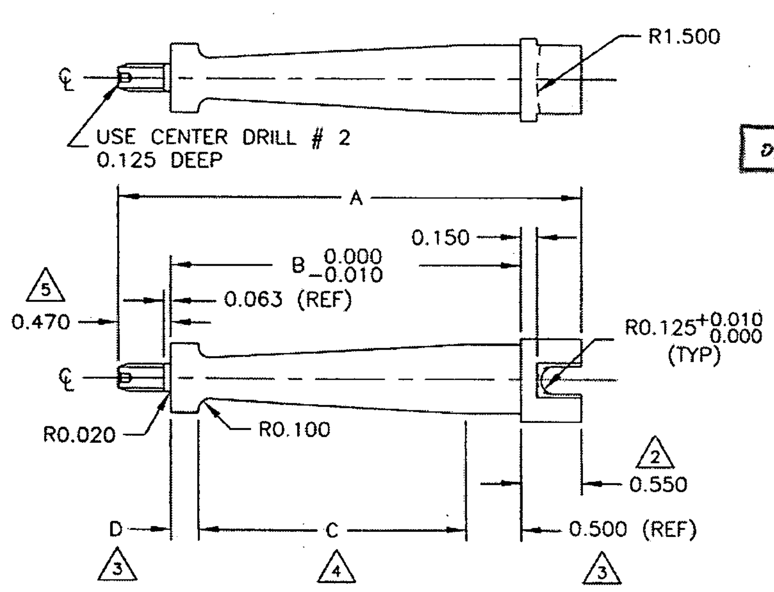
W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

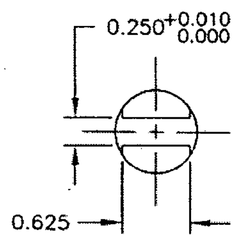
QA: N/C Closed: _____ **Date:** _________

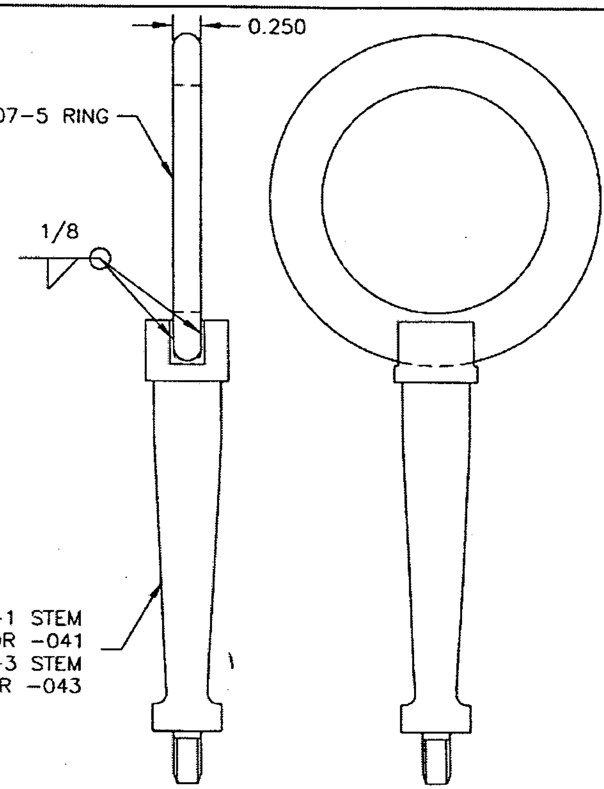
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section.B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries



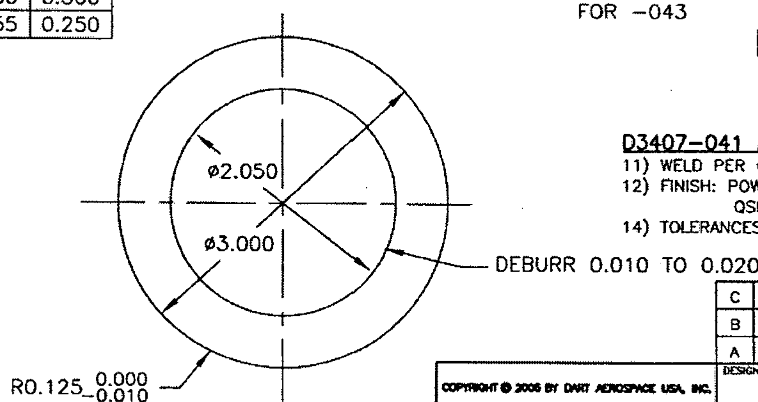
RELEASED
05.09.12





PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

D3407-1/-3 STEM



D3407-5 RING

D3407-1 AND D3407-3 STEM:

1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
2) ⌀0.750 O.D.
3) ⌀0.625 O.D.
4) MACHINE UNIFORM TAPER FROM ⌀0.363 O.D. TO ⌀0.625 O.D.
5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
7) UNLESS OTHERWISE INDICATED
8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-5 RING:

9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D3407-041 AND D3407-043 TOW RING:

11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REV	DATE	DESCRIPTION
C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE

DESIGN: CP | DRAWN BY: CP | CHECKED: [signature] | APPROVED: [signature]

DATE: 05.09.09

DART — DART AEROSPACE USA, INC. PORT HADLOCK, WA

DRAWING NO. D3407 | REV. C | SHEET 1 OF 1

TITLE: TOW RING | SCALE 1:1